



7780

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G19432-3G**Job Sheet 186569****Part No:** RBW6205G19432-3G**Job Qty:** 4 pcs**Part Name:** Main Rotor Scissor Bushing Install Tool**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/17/18**Job Tracking No:****Due Date:** 12/28/18**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG RBW6205G19432-3G Rev 2 IPP Rev A 18.03.12 New issue DP Verify DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	4 pcs	12/28/18		0.00	0.67	Small Fab - 1		
							Small Fab - 2		MLC
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	4 pcs	12/28/18		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		358 19/10/18
130	Packaging 3-1 - Stock - B4B	4 pcs	12/28/18		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

**Container No:** S148544**Part:** RBW6205G19432 - 3G**Job No:** 186569**Serial No/Batch:** S148544**Revision:** 2**Inspector:****Exp Date:****Instructions:**

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/28/19

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLL
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	4 pcs	12/28/18	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70

Part Op **100** - Assemble as per DWG. Apply a small amount of Bronze anti-sieze to threads of steel nut.
 Descriptions: **110** - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____) Identify and Stock
140 - (QC21- Final Inspection - Work Order Release)

DAS
21
9-88

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GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
34 NTA-916	Thrust Bearing	4 Ea (1 ea)	100-Small Fab - 1	5105371
94 RBW6205G19432-3G-1	Draw Bolt	4 Ea (1 ea)	100-Small Fab - 1	5145995
99 RBW6205G19432-3G-3	Receiver	4 pcs (1 ea)	100-Small Fab - 1	5133082
11 RBW6205G19432-3G-5	Sleeve	4 pcs (1 ea)	100-Small Fab - 1	+ 5141766
11 RBW6205G19432-3G-7	Washer	4 pcs (1 ea)	100-Small Fab - 1	5132187
36 TRA-916	Thrust Washer	8 Ea (2 ea)	100-Small Fab - 1	5105366
65 90565A333	Nut, Steel	4 Ea (1 ea)	100-Small Fab - 1	5105395

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90565A333	4	42	0
	NTA-916	4	20	0
	RBW6205G19432-3G-1	4	4	0
	RBW6205G19432-3G-3	4	4	0
	RBW6205G19432-3G-5	4	4	0
	RBW6205G19432-3G-7	4	4	0
	TRA-916	8	40	0

Part Specifications
Specifications could not be found.

Plex 1/23/19 3:01 PM Dart.Hadley.Shannon



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RBW6205G19432-3G

Job Sheet 186569



Part No: RBW6205G19432-3G

Job Qty: 4 ea

Part Name: Main Rotor Scissor Bushing Install Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/17/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *5th*

Description:

Note: DWG RBW6205G19432-3G Rev 2 IPP Rev A 18.03.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/28/18	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	4 pcs		12/28/18	0.00	0.67	Small Fab-9		
110	QC	4 pcs		12/28/18	0.00	0.00	QC5		
130	Packaging	4 pcs		12/28/18	0.00	0.00	Packaging3-2		
140	QC21-FG	4 Ea		12/28/18	0.00	0.00	QC21		

Part Op 100 - Ass
Descriptions: 130 - Ide

NOTE: Add a small amount of Bronze anti-sieze to threads of steel nut.

Part / Item

NTA-916

RBW6205G19432-3G-1

RBW6205G19432-3G-3

RBW6205G19432-3G-5

RBW6205G19432-3G-7

TRA-916

90565A333

Operation

Start up Operation

Start up Operation

Start up Operation

Start up Operation

Start up Operation

Start up Operation

Start up Operation

Container

Operation

90-Start up Operation

RBW6205G19432-3G-3

RBW6205G19432-3G-5

RBW6205G19432-3G-7

TRA-916

Required

1

1

1

1

4

4

8

Inventory

10

20

0

0

0

0

30

Allocated

0

0

0

0

0

0

0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

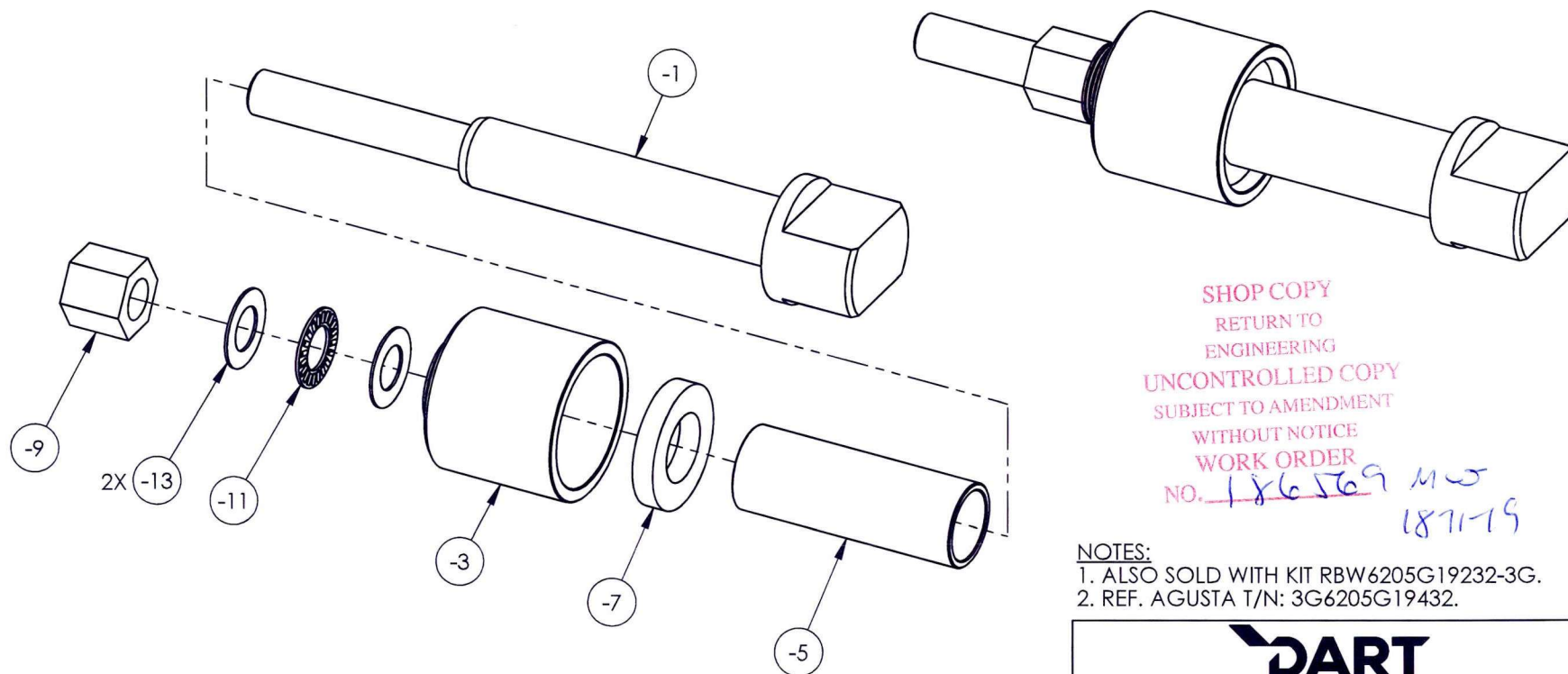
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		BECAUSE OF DIFFERENT ENGRAVINGS CREATED -18 RECEIVER TO REPLACE -07 ON TOOL RBW6205G19432-3G. ADDED ENGRAVING NOTES TO -07 & -18. ADDED -3G TO ALL PART NUMBERS. TO -27 ADDED REF. DIMENSIONS. ON -3 & -17 DRAW BOLTS CHANGED ENGRAVINGS FROM T/N, S/N, ECT. TO T/N ONLY.	9/21/2009	WP	RW
2	16-0031	UPDATED TO NEW STANDARDS. -1, -5, -7 CH'D FINISH WAS YELLOW ZINC PLATE IS ZINC PLATE ASTM B633 TYPE I SC2. --1 ADDED MAT'L OPTION 4142 Q&T. CH'D FINISH WAS YELLOW ZINC PLATE IS ZINC PLATE ASTM B633 TYPE I SC2. CH'D DIMS WAS 2.950 IS 2.95, WAS .946 IS .95, WAS .120 IS .12, WAS 7.276 IS 7.28, WAS 1.572 IS Ø1.57. -3 CH'D DIMS WAS 3X .015 X 45° IS 3X .02 X 45°, WAS 1.970 IS 1.97, WAS .215 IS .22, WAS 1.256 IS 1.26. ADDED ENGRAVE NOTE. -5 CH'D DIMS WAS 4X .015 X 45° IS 4X .02 X 45°, WAS 2.950 IS 2.95. -7 CH'D DIM WAS .276 IS .28. -9 CH'D DIM WAS .882 HEX IS 3X .88.	2/11/2016	DPD	JAG



- NOTES:
 1. ALSO SOLD WITH KIT RBW6205G19232-3G.
 2. REF. AGUSTA T/N: 3G6205G19432.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	DRAW BOLT	4140/4142 Q & T		2
			-3	1	RECEIVER	6061		3
			-5	1	SLEEVE	1018/1020 CR		4
			-7	1	WASHER	1018/1020 CR		5
			-9	1	TALL NUT	BRONZE ALLOY 642		6
		B/O	-11	1	THRUST BEARING	STEEL	Ø.562 I.D. X Ø1.000 O.D. X .0781 (APPLIED #NTA-916)	1
		B/O	-13	2	THRUST WASHER	STEEL	Ø.562 I.D. X Ø1.000 X .031 (APPLIED #TRA-916)	1

DART AEROSPACE	
TITLE M/R SCISSOR BUSHING INSTALL TOOL	
DWG NO. RBW6205G19432-3G	REV 2
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AGUSTA AW139
SCALE 1:2	DATE 7/8/2009
SHEET 1 OF 6	